

76260

Page 1

N900040100

Setup Start ***NS1***

Stop *NS2*

17

17

Run Start *NR1*

Stop *NR2*

Date:

Draw Nbr	Revision Nbr
D3660	Rev B

0.00

17 \emptyset

0.00

Cut blank 7.300 " long

0.00

17 ✓

0.00

1-Turn as per folio FA 708 & DWG D3660,
FOLIO REV: B
DWG REV: B
2-Deburr as required

0.00

17 ϕ

0.00

Quality Control

Work Order ID 76260

November-08-11 11:24:49 AM

76260

Page 2

Item ID: D3660-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: CUFF
Start Date: 11/07/11 Start Qty: 17.00 ***17*** Cust Item ID:
Required Date: 11/10/11 Req'd Qty: 17.00 ***17*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				17	0		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				17.		B 11-11-9	
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				17X0		M 11/11/09	

Work Order ID 76260

76260

Page 3

November-08-11 11:24:49 AM

Item ID: D3660-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: CUFF
 Start Date: 11/07/11 Start Qty: 17.00 ***17*** Cust Item ID:
 Required Date: 11/10/11 Req'd Qty: 17.00 ***17*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>402</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

11/11/11
 mr
 11-11-11

Picklist Print

November 8, 2011 3:08:45 PM

Page 1

Work Order ID: 76260

Parent Item: D3660-1

Parent Item Name: CUFF

Start Date: 07/11/2011

Required Date: 10/11/2011

Start Qty: 17.00

Required Qty: 17.00

Comments: IPP rev A new issue 07.09.19 EC verified by:JLM
IPP Rev:B 08-04-07 chg to revB DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6008-180 Crosstube Extrusion		Manufactured	No			100	Each	21.0000	0.056	1.0021053			

Location	Loc Qty	Loc Code
LG	21	
46779	6	
59249	15	

6008- 132

B 50892

~~3.8 At~~
4.5 At

6009 - 129

B 65179

6.5 At

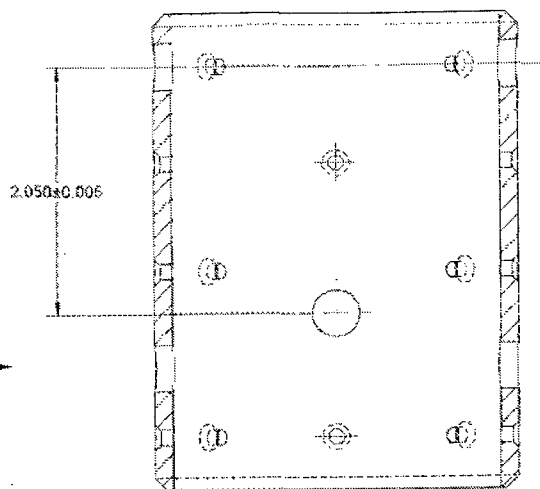
used scrap material

DRILL #30 (Ø0.128 REF)
CSINK Ø0.230X100"
TYP 22 PLACES

Ø0.366^{+0.005}
-0.000
HOLE TO BE ALIGNED
WITHIN ±0.001 OF HOLE
ON OTHER SIDE OF CUFF.
TYP 6 PLACES

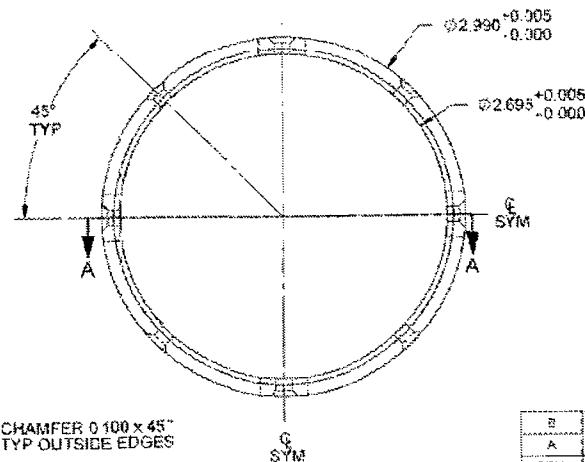
NOTES:

- 1) MATERIAL: 7075-T6/T6511 SEAMLESS TUBE (WWT-7007 OR QQ-A-225/B OR QQ-A-200/11)
(CAN MAKE FROM D6006, D6006, OR D6006)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs



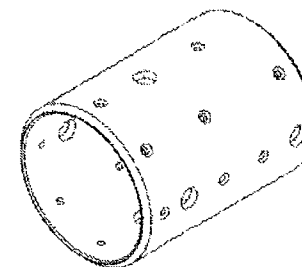
R0.032 TYP
INSIDE EDGES

SECTION A-A



CHAMFER 0.100 x 45°
TYP OUTSIDE EDGES

D3660-1 CUFF



76260

B	ADD Ø0.128 & Ø0.366 HOLES (B6)	CP	08.35.03
A	NEW ISSUE	CP	07.37.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR			
APPROVED			
DE APPR			
DATE	08.03.03		

DART AEROSPACE LTD
-HAWKESBURY, ONTARIO CANADA

DRAWING NO.
D3660

REV. B
SHEET 1 OF 1

TITLE
CUFF

SCALE
NTS

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